

Date: Wednesday, 2/20/2008 4:14:41 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ANGLE BRACKET
Job Number	: 37508		
Estimate Number	: 10891		
P.O. Number	:	Part Number	: D32581
This Issue	: 2/20/2008 S.O. No. :	Drawing Number	: D3258 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A
Previous Run	: 29912	Material	:
Written By	:	Due Date	: 3/3/2008
Checked & Approved By	:	Qty:	6 Um: Each
Comment	: Est B 05.11.01 Added Steps 6-7 KJ/JLM Est Rev:C Now on Waterjet 06-12-13 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0053 sf(s)/Unit Total : 0.0315 sf(s)

304/316 .063 Sheet 16 Gauge

Batch: 106860 HB 8-2-22

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3258

Dwg Rev: A

Prog Rev: A

HB 8-2-22



2-Deburr if necessary

HB 8-2-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-2-22

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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HB 8-2-22 (11)

Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary
Form as per Dwg D3258

HB 08/03/03



HB 08/02/27 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 28/03/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:14:42 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE BRACKET

Job Number: 37508

Part Number: D32581

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 28/03/08 (11)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5779*

Handwritten: 28/03/08 (11)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 28/03/08 (11)

Job Completion



Handwritten: 2008/3/04 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

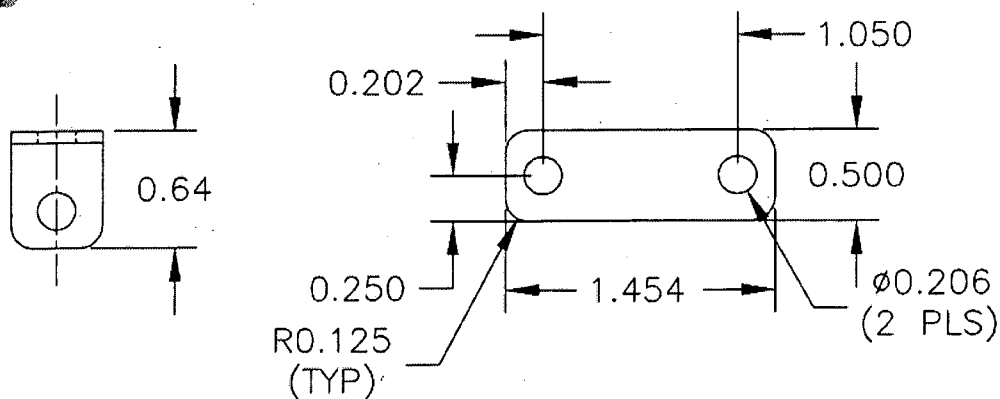
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

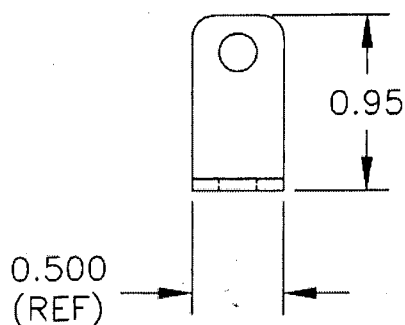


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3258	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE ANGLE BRACKET	SCALE 1:1
A	04.01.27	NEW ISSUE	

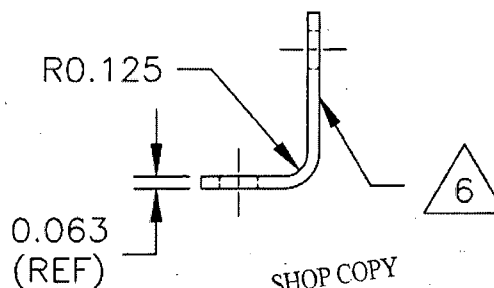
RELEASED
04.04.06



D3258-1 FLAT PATTERN



D3258-1 ANGLE BRACKET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37508

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 to 0.015
- 2) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK (REF. DART SPEC. M304S16GA)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

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